

Work Order ID 75947

75947

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November-02-11 8:34:33 AM

Item ID: D3190-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Chafing Shield
 Start Date: 02/11/2011 Start Qty: 10.00 ***10*** Cust Item ID:
 Required Date: 16/11/2011 Req'd Qty: 10.00 ***10*** Customer:
 Reference:

Approvals: Process Plan: M.L.J Date: 11/11/02 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3190	Rev A								

100		0.00							
100									
Waterjet	Memo	0.00							
FLOW CNC Waterjet	CUT AS PER DWG								
<u>304 . 020</u>	DWG REV: <u>A</u>								
	PROG REV: <u>A</u>								
105	QC2- Inspect parts off machine FAI/FAIB	0.00							
105									
QC	Memo	0.00							
Quality Control									
106	QC8- Inspect parts - second check	0.00							
106									
QC	Memo	0.00							
Quality Control									

B11-11-8

(23)

B11-11-8

count
(23)

Sululos

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Packaging

W/O:		WORK ORDER CHANGES					
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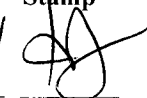
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Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC21- Final Inspection - Work Order Release	0.00							
130									
QC	Memo	0.00							
Quality Control									

11/11/14 
11/11/11
(23)

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Picklist Print

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Work Order ID: 75947

75947

Parent Item: D3190-1

D3190-1

Parent Item Name: Chafing Shield

Start Date: 02/11/2011

Required Date: 16/11/2011

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A03.05.26New issueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S25GA		Purchased	No			100	sf	109.5000	0.2153	2.266316	5,		
M304S25GA									**	181-11-8			

304/316 .020" Sheet

Location

Loc Qty

Loc Code

MAT20

109.5

117285

5.5

118228

104

118228

(23)

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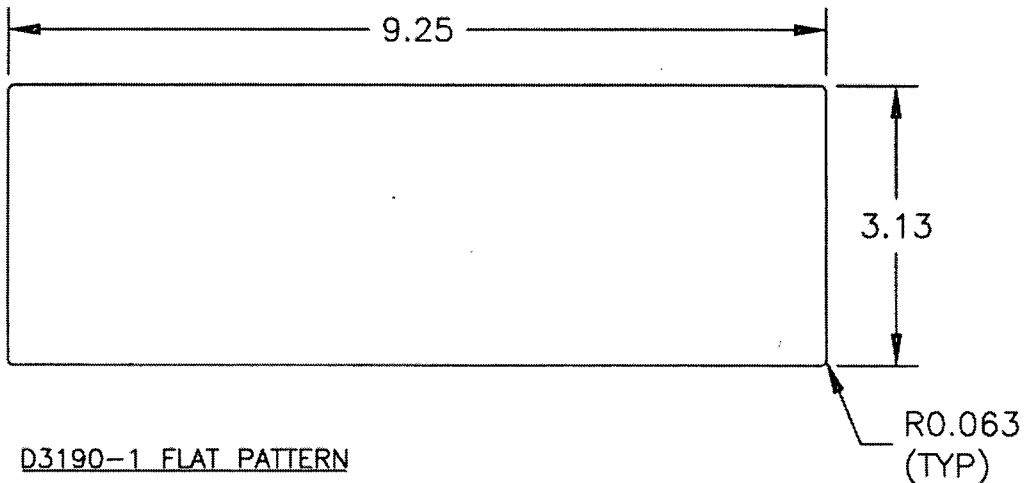
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DESIGN #	DRAWN BY UP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3190	REV. A SHEET 1 OF 1
DATE 03.05.16		TITLE CHAFING SHIELD	SCALE 1:2
A	03.05.16	NEW ISSUE	

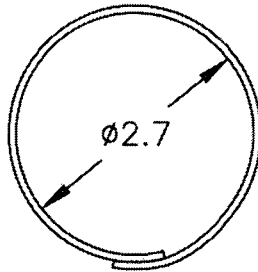
RELEASED
03.05.22 #



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER

75947 H.C.D

11/11/02



D3190-1 ROLLING DETAIL
NOT TO SCALE

D3190-1 CHAFING SHIELD

- 1) MATERIAL: AISI 304/316 SS 0.020" THICK (REF. DART SPEC M304S25GA)
- 2) FINISH: NONE
- 3) DEBURR/BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES

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